

Date: Friday, 01/08/2008 10:42:46 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STRUT
 Job Number : 40901
 Estimate Number : 11046
 P.O. Number :
 This Issue : 01/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2814
 First Issue : / / Type : MACHINED PARTS Drawing Number : D2814 REV A1
 Previous Run : 38779 Project Number : N/A
 Material :
 Due Date : 20/08/2008 Qty: 6 Um: Each
 Written By :
 Checked & Approved By : JUL 08.8.05
 Comment : Est. C 02.06.18 Added finishing level (Ref. ECN 435) KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 2-1000 f(s)/Unit Total: 12-6000 f(s) 6.000

304 RD Tube .500 x .035W

Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per Dwg D2810 and spec control

Dwg D2727 using Jig DT8012

Batch: M107907 (2)

M108250 (10) SB 08/08/21 (12)

2.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012

2-Deburr 22/21 08/08/22 (12)

SB 08/08/21 (12)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2 08/08/22 (12)

4.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 9-20

OVEN TEMPERATURE: 400°F

FINISH TIME: 9-50

M108523

(12X)

M-1 08/08/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/08/26	1	permanent change		08/08/26		u	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 10:42:47 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 40901

Part Number: D2814

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-25

(X12)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 265

JS 08/08/28

(X12)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08-08-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

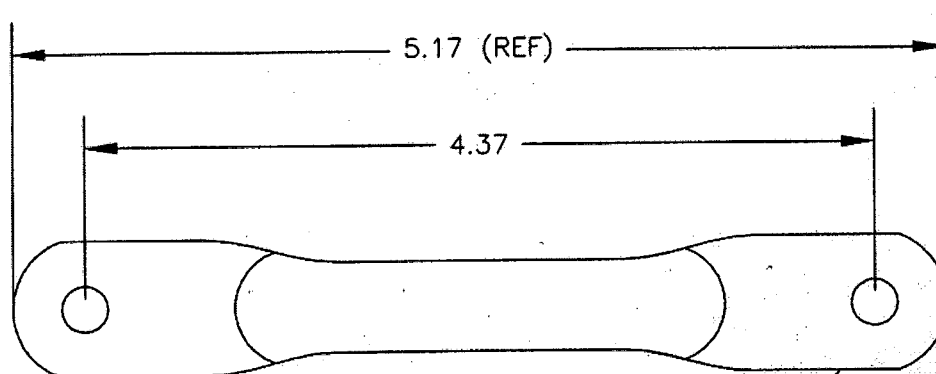
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2814	REV. A SHEET 1 OF 1
DATE 99.09.29		TITLE STRUT	SCALE 1:1
A	99.09.29	NEW ISSUE	
A1	CP # 02.03.26	ADD FINISH	

RELEASED
99.10.12 **KE**PUNCH ENDS PER SPEC
CONTROL DRAWING D2727

NOTE:
MATERIAL: 304/316/318 SS, 0.50 OD x 0.035 WALL,
ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QAS 4.3 **AI**

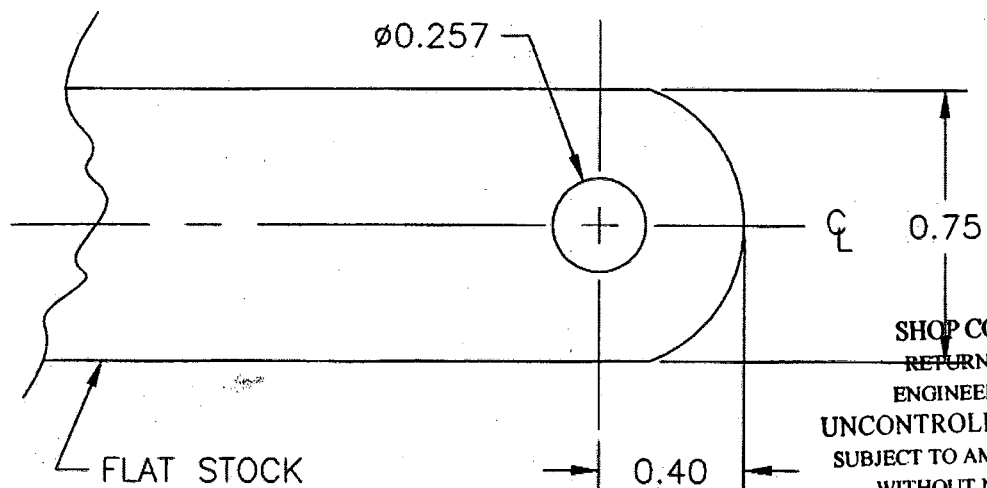
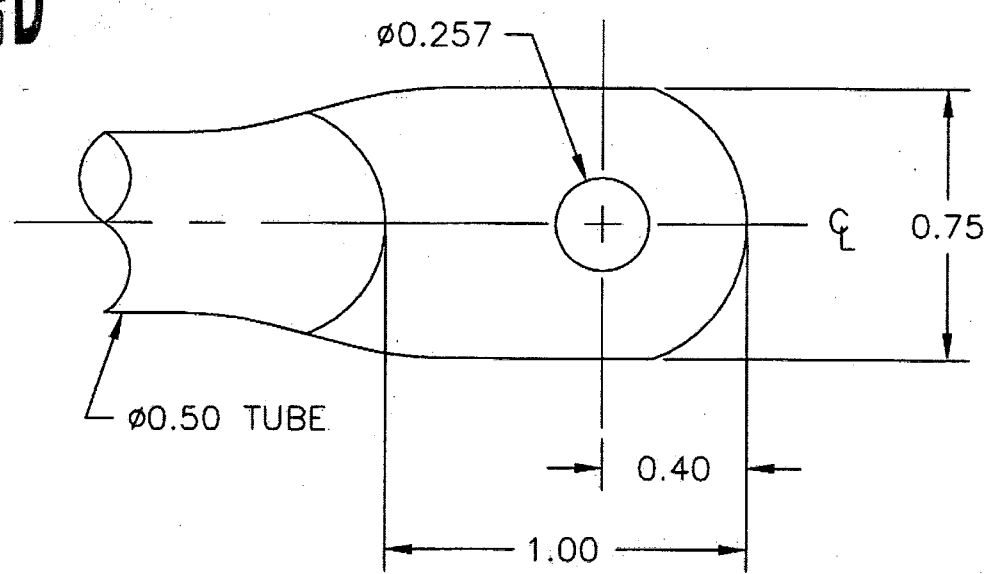
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WORK ORDER
NO. **40901**



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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	#CP 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8012

RELEASED
98/03/06 KE



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NO. 40901

NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.